User

Thursday, 02/11/2006 8:21:02 AM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29180

Estimate Number

: 11385

P.O. Number This Issue

:NIA : 02/11/2006

S.O. No. : NA

Prsht Rev. First Issue

Previous Run

: MACHINED PARTS

: 29180

Written By

Checked & Approved By

Comment

: Est.

03.10.23

New issue KJ/DS 06.10.31

esr

waterjet

Drawing Name

: COUPLING BRACKET

Part Number

: D3225041 : D3225 REV A

Drawing Number Project Number

: N/A

Drawing Revision

Material Due Date

: 07/11/2006

Qty:

Each 2 Um:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

2024-T3 .050 sheet

Description:

1.0

M2024T3S050



Comment: Qty.: 0.1093 sf(s)/Unit Total:

0.2186 sf(s)

2024-T3 .050 sheet

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050) Identify for D3225-1

2.0



Comment: FLOW WATER JET

1-Cut as per Dwg D3225 Dwg Rev: A

Prog Rev: A

M 06 11 02

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK





Comment: CUDAROOT Der Helloopter's Services Drawfing Name: COUPLING BRACKET Job Number: 29180 Part Number: D3225041 Job Number: 29180 Seq. #: Machine Or Operation: Seq. #: Machine Or Operation: Seq. #: Machine Or Operation: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3226. Dimple rivel hole. 50 Comment: INSPECT WORK TO CURRENT STEP AND FRISHING RESOURCE #1 Chemical Conversion Coal as per QSI 005 4.1 Comment: POWDER COATING POWDER COATI	Date: User:		sday, 02/11/2006 8:21:02 AM $5\hbar$ a Lacelle	Process Sheet		
Job Number: Seq. #: Machine Or Operation: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3225. Dimple rivet hole. Comment: NISPECT WORK TO CURRENT STEP Comment: NISPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3 9.0 GC3 INSPECT POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.5 Comment: NISPECT POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.5 Comment: NISPECT POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.5 Comment: NISPECT POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.5 Comment: NISPECT POWDER COATING CAMIL.OC Pick: QIY Part Number Description 1 7 C124W Camiloc T 7 C124W Camiloc Rivet Pick: QIY Part Number Description Batch 1 MS20428AD5-7 Rivet M 7 C9 /	С	ustomer:	CU-DAR001 Dart Helicopters Services	Drawing Name:	COUPLING BRACKET	
Seq. #: Machine Or Operation: 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3225. Dimple rivet hole. 6.0 QCS INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP Themical Conversion Cost as per QSI 005 4.1 Comment: POWDER COATING POWDER COATING POWDER COATING POWDER COATING OC3 INSPECT POWDER COMMENCIAL CONVERSION Comment: INSPECT POWDER COATING POWDER COATING Comment: INSPECT POWDER COATING Comment: POWDER COATING POWDER COATING Comment: POWDER COATING TO COMMENT: POWDER COATING Comment: POWDER COATING POWDER COATING Comment: POWDER COATING TO COMMENT: POWDER COATING COMMENT: POWDER COATING POWDER COATING COMMENT: POWDER COATING TO COMMENT: POWDER COATING COMMENT: POWDER COATING COMMENT: POWDER COATING TO COMMENT: POWDER COATING COMMENT: POWDER COATING COMMENT: POWDER COATING COMMENT: POWDER COATING TO COMMENT: POWDER COATING COMMENT: POWDER COATING COMMENT: POWDER COATING TO COMMENT: POWDER COATING COM	Job	Number:	29180	Part Number:	: D3225041	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3225. Dimple rivet hole. 8.0 CC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 1.0 HAND FINISHING RESOURCE #1 Chemical Conversion Coal as per QSI 005 4.1 POWDER COATING POWDER COATI	Job Nur	mber:				
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SB DL 37		0.0				
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) CAMLOC Pick:		9.0		INGI EOTT ONDER GORMON		_
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) CAMLOC Pick: Qty Part Number Description Batch 1 7C124W Camloc Mode 2 5 11.0 MS20426AD57 Rivet Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Rivet Pick: Qty Part Number Description Batch 1 MS20426AD5-7 Rivet M 769/					SB 06/11/07	(S
CAMLOC Pick: Qty Part Number Description Batch 1 7C124W Camloc Mode of Sto Duli(09) 11.0 MS20426AD57 Rivet Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Rivet Pick: Qty Part Number Description Batch 1 MS20426AD5-7 Rivet M 769/		10.0	7012444	CAIVILOC		_
Qty Part Number Description Batch 1 7C124W Camloc Mode 25 11.0 MS20426AD57 Rivet Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Rivet Pick: Qty Part Number Description Batch 1 MS20426AD5-7 Rivet M 7691		Comme	CAMLOC	: 2.0000 Each(s)		À
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Rivet Pick: Qty Part Number Description Batch 1 MS20426AD5-7 Rivet M 7691		· · · · · · · · · · · · · · · · · · ·	Qty Part Number Description 1 7C124W Camloc	M 103 63 12	50 06/11/09	<u>े</u>
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Qty Part Number Description Batch 1 MS20426AD5-7 Rivet M 7691		Comme	Rivet	: 2.0000 Each(s)		
A/R Contact Cement M 100374 SB 86/4/09 0			Qty Part Number Description B. 1 MS20426AD5-7 Rivet	atch <u>M 768</u> /	·	
			A/R Contact Cement M	100374	SB 86/4/09	IJ

Date:

Thursday, 02/11/2006 8:21:02 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COUPLING BRACKET

Job Number: 29180

Part Number: D3225041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALI MEDIUM FAB RESOURCE 1

Fabricate D3225-3/-5 packers from D2397 rubber as per Dwg

D3225.Batch: 18 16 97

Assemble as per Dwg D3225.

Bond D3225-3/-5 to camloc using contact cement.

Identify as D3225-041

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kwik Float Cell

Location:

06.11.09

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



MUSTSHIP NOV. 84h Dart Aerospace Ltd.

Thursday, 10/26/2006 8:25:22 AM

User:

Kim Johnston

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

: 29180 Job Number : 11385 **Estimate Number**

P.O. Number

This issue

: NC Prsht Rev.

First Issue

: 10/26/2006 S.O. No. :

: //

Type

: MACHINED PARTS

Part Number Drawing Number

Drawing Name

: D3225041 . D3225 REV A

: COUPLING BRACKET

Project Number

Drawing Revision

Material

Due Date

: 11/7/2006

: N/A

: A

Qty:

2 Um: Each

Previous Run

Written By

Checked & Approved By Comment

Additional Product

a

Joh Number:



Seq. #:

Machine Or Operation:

Description:

M2024T3S050

2024-T3 .050 sheet



Comment: Qty.:

Total: 0.1093 sf(s)/Unit

0.2186 sf(s)

2024-T3 .050 sheet

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050) Identify for D3225-1

Batch:

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 2.785" x 4.920" grain along 4.920"

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA378 and Dwg D3225

Stack of 10

Deburr break all unmarked sharp edges 0.005 to 0.010

Identify as D3225-1

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3225. Dimple rivet hole.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
06/11/09	10	Transfer Hole From bracket to Camloc and dimple rivet hole took a (-7) rivet and grind down to (-5)	NA NA	26.11.09		W do:11:09	E			

Part No: _	 PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>\(\lambda</u>
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector
06/1/07	5	Part was bent on wrong side (Iscrap)			M/ B 11 07	06/11/07	Was was	06-01-10
	42							

NOTE: Date & initial all entries

Thursday, 10/26/2006 8:25:22 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: COUPLING BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 29180 Part Number: D3225041 Job Number: Description: Seq. #: **Machine Or Operation:** SECOND CHECK QC8 Comment: SECOND CHECK HAND FINISHING HAND FINISHING RESOURCE #1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION CAMLOC Bitch clary book 10.0 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: **CAMLOC** Pick: Batch Description Qty Part Number 70124W Camloc 11.0 MS20426AD57 Rivet Comment: Qty.: 2.0000 Each(s) 1.0000 Each(s)/Unit Total: Rivet Pick: Qty Part Number Description Batch MS20426AD5-7 Rivet A/R **Contact Cement** SMALL & MEDIUM FAB RESOURCE 1 12.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Fabricate D3225-3/-5 packers from D2397 rubber as per Dwg D3225.Batch: Assemble as per Dwg D3225. Bond D3225-3/-5 to camloc using contact cement.

Dart Aerospace Ltd

DuitAc	ospace	Ltu								
W/O:			WO	RK ORDER CHAN	NGES					
DATE	STEP	PR	OCEDURE CHAP	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
#4. ¹										
Part No	:	PAR #:	Fault Categ	gory:	NCF					
_, .	····				<u> </u>			d:	Date:	
NCR:		·	WORK ORDE	ER NON-CONFORI	MANCE	(NCR	2)			
DATE	STEP	Description of NC	Corrective Action Section B			Verifica		cation	ation Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Secti	on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

Date:

Thursday, 10/26/2006 8:25:22 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COUPLING BRACKET

Job Number: 29180

Part Number: D3225041

Job Number:



Seq. #:

Machine Or Operation:

Description:

Identify as D3225-041

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kwik Float Cell

Location:

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Job Completion

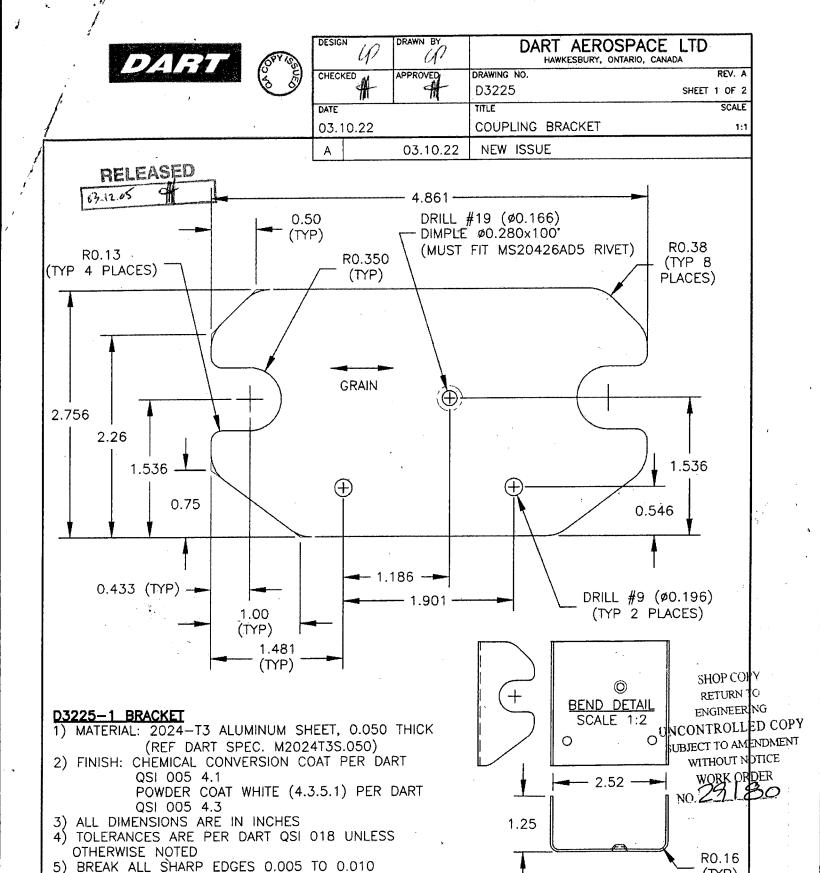


Comment: FINAL INSPECTION/W/O RELEASE

Dart Ae	rospac	e Ltd	*						
W/O:			WC	ORK ORDER CHANGES	<u> </u>				
DATE	STEP	PR	OCEDURE CHA	NGE	By Date			Approval Chief Eng / Prod Mgr	Approval QC Inspector
<u> </u>									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	:	_ Date: _	
					QA: N	C Closed:		_ Date:	
NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
DATE	OTED	Description of NC	Corrective Action Section B			Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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NOTE: Date & initial all entries





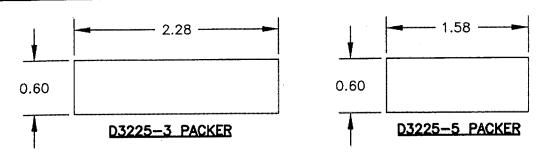
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(TYP)

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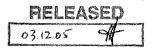


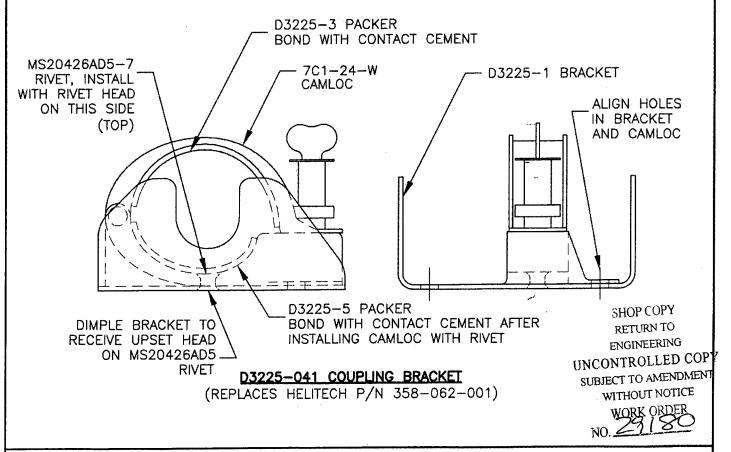
DESIGN	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO	
CHECKED	APPROVED A	DRAWING NO.	REV. A
d	4	D3225	SHEET 2 OF 2
DATE		TITLE	SCALE
03.10.22		COUPLING BRACKET	1:1



D3225-3/-5 PACKER

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/16" THICK (D2397)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





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DART AEROSPACE LTD	Work Order:	29180
Description: Coupling Bracket	Part Number:	D3225-1
Inspection Dwg: D325 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
00.196	to.005-0.001	0.196	J		Vern	
of 0.166	+0.005-0.001		√		Verd	
2.756	+1-0.010	2.762	\checkmark		Verv	
2.26	+1-0.030	2.26	√.		VEVN	
4.861	+1-0.010	4.860	J		Vern	
1.536	+1-0.010	1.539	1		Verd	
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	-	* 4				

Measured by: M: M	Audited by:	Prototype Approval:	
Date: 8/102	Date: WellOZ	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	